Work Order ID 63375 Thursday, October 28, 2010 10:20:29 AM						m mindre state				<u> </u>		Page
Item ID: Revision ID:	D206-642-54	11		Accept					Setup			
Item Name: Start Date: Required Date: Reference:	Replacement S 10/28/2010 11/11/2010	Skidtube Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D:				Stop		
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr										
D3274	D											

DOCUMENT CONTROL

Rev M

Memo

0.00

0.00

Document Control

IIN-D206-642

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

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W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP-	PRO	CEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	_ Fault Categ	gory:	NCR: Yes	No DQA :	Date: _	
	R	esolution:	Disposition	ı:	_ QA: N/C Cld	sed:	Date: _	
NCR:		W	ORK ORDE	ER NON-CONFORMA	NCE (NCR)	· · · · · · · · · · · · · · · · · · ·	• .
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
	wing to							

Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

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Approvais:

Required Date: 11/11/2010

Process Plan: _____ Date:

_____ Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

110

Skidtubes Skidtubes

Operation Description

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept **Qty**

Reject Qty

Reject Number

Insp. Stamp

Skidtubes

Memo

0.00

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foilo 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: M11385 M115776

BE 10-11-03

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

4- grind fwd cap weld on top surface only

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	\:	_ Date: _			
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NCR:			WORK ORI	DER NON-CONFORMA	NCE (NCF	R)					
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Work'Order ID 63375 Thursday, October 28, 2010 10:20:29 AM									"		-	Page 3
Item ID: D206-642-541 Revision ID:				Accept					Setup	Start	1 (861)(8) 6)	
Item Name: Start Date: Required Date: Reference:	Replacement 10/28/2010 11/11/2010	Skidtube Start Qty: 1.00 Req'd Qty: 1.00			Cust Item II Customer:	D:				Stop		
Approvals:		an:		Tooling: SPC (Y/N):	Da	te:			Run	Start Stop		
Sequence ID/ Work Center II 120	D	Operation Description Chemical Conversion Co	pat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	ject y	Reject Number	Insp. Stamp
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130 QC Quality Control		QC3- Inspect Part Finish Memo	ı	0.00	1			_/		<u> </u>	_BE	E vofufio
140 		QC5- Inspect part compl	leteness to step on W/O	(2000) 2 (2010)	(((Fi)			**************************************	

Quality Control

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		WO	RK ORDER CHANGE	ES		-		t
STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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R	esolution:	Disposition	QA: N/C Clo	sed:		Date:		
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	STEP	PAR #:	STEP PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	WORK ORDER CHANGE PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Corrective Action Section	WORK ORDER CHANGES STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes for the process of the	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQA Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Sign & Verifical Section A Section B Section A Section A Section B Se	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section C Section C Section C Section C Section C Chief Eng (NCR)

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Thursday, October 28, 2010 10:20:29 AM

D206-642-541



Page 4

Item Name:

Item ID:

Revision ID:

Replacement Skidtube

Start Date: **Required Date:** 11/11/2010

10/28/2010 Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

QC: ______ Date: _____ SPC (Y/N):

Operation

Description

Skidtubes

Tool ID

Tool # Plan

Date:

Date:

Accept Code Qty

Reject Qty

Run

Setup Start

Stop

Start

Stop

Reject Insp. Number Stamp

150

Sequence ID/

Work Center ID

Skidtubes

Skidtubes

Memo

0.00

0.00

Tooling:

Set Up/

Run Hours

Accept

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015. A/R | Sikaflex-291 | 116 040' | D

(Adhere for 12 hours)

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

W/O:		WORK ORDER CHANGES				*	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							

Part No:	PAR #:	_ Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

	WORK ORDER NON-CONFORMANCE (NCR)									
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Quality Control

Thursday, October 28, 2010 10:20:29 AM



Page 5

Item ID: D206-642-541 Accept Setup Start Revision ID: Item Name: Replacement Skidtube Stop Start Date: 10/28/2010 Start Qty: 1.00 **Cust Item ID: Required Date:** 11/11/2010 **Req'd Qty:** 1.00 Customer: Reference: Start Run Process Plan: Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Otv Oty Number Stamp 170 0.00 Skidtubes Skidtubes 0.00 Memo 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install Skidtubes drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding 180 QC5- Inspect part completeness to step on W/O Memo

Dart Aeros	pace Ltd
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W/O:				WORK ORDER	CHANGES				,
DATE	STEP		PR	OCEDURE CHANGE	В	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•		PAR #:	Fault Category:	NCR: \	es No D	QA:	Date: _	
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Work Order ID 63375

Thursday, October 28, 2010 10:20:29 AM



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Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00 **Required Date:** 11/11/2010

Operation

Skidtubes

Description

Req'd Qty: 1.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____

Date:_____

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Run

Reject

Qty

Start

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ **Work Center ID**

190

Skidtubes Skidtubes

Memo

Memo

0.00

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use

aluminum rod A/R□□Aluminum Rod□

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200

Quality Control

QC5- Inspect part completeness to step on W/O

sister 26 MM

Accept

Qty

Dart Ae	rospace	e Ltd							
W/O:			WO	RK ORDER CHANGE	S			,	•
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Work Order ID 63375

Thursday, October 28, 2010 10:20:29 AM



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Item ID:

D206-642-541

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan: ____ Date: ___

Tooling: SPC (Y/N):

Date:

Date:

Run Start

Stop

Stop



Sequence ID/ Work Center ID

210

Operation Description

QC10- Inspect visual per QSI004- ground welds

______ Date:_____

Set Up/ **Run Hours**

Tool ID

Tool # Plan Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Quality Control

Pressure Wash per QSI005 4.3

Memo

0.00 7 11 10/1/29

Memo

0.00

0.00

HandFinish Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

1 blo-1130.

Powdercoat

Powder Coating

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W/O:			WC	RK ORDER CHANG	ES	-		,	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
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NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
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Work Order ID 63375

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Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Required Date: 11/11/2010

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Reg'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____

______ Date: _____ SPC (Y/N):

Tooling:

Date: Date:

Tool # Plan

Run

Start



Stop

Sequence ID/ **Work Center ID**

240

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00 => H 10/11/30

Code Qty

Accept Reject Oty

Reject Number Stamp

Insp.

250

HandFinish

Hand Finishing

HandFinishing

Memo

10/11/27

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. \triangle A/R \square N/A \square LPS-3 \square M1(39956)

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R□□Sikaflex-291 □ Λ(11≤) (Ш

Sikaflex expire date:

260

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Nut Plate & Inserts

M 10 11 30 (1)

	WORK ORDER CH	ANGES			,	,
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
	STEP		STEP PROCEDURE CHANGE By			STEP PROCEDURE CHANGE By Date Qty Chief Eng /

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
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Work Order ID 63375

Required Date: 11/11/2010

Thursday, October 28, 2010 10:20:29 AM



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Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

10/12/08

Reference:

Approvals:

Process Plan: ____ Date: ____

QC:

Operation

Description

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Date:

Run

Reject

Qty

Accept

Qty

Start

Stop

Stop

Reject

Number Stamp

Insp.

Sequence ID/ Work Center ID

270

HandFinish Hand Finishing HAND FINISHING RESOURCE #1

Memo

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274 Sikaflex expire date: 1110 L

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3 Batch: NA LPS-3

Sikaflex expire date:

QC5- Inspect part completeness to step on W/O

11101

Memo

0.00

0.00

280

Quality Control

W/O:	WORK ORDER CHANGES						•	•			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

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Work Order ID 63375

Thursday, October 28, 2010 10:20:29 AM



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Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010 Req'd Qty: 1.00



PM 62758

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date: Date: Run

Start Stop

Stop

Date:

SPC (Y/N):

Set Up/

Tool # Plan

Code Qty

Accept Reject Qty

Reject Number

Insp. Stamp

Work Center ID 290

Sequence ID/

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Run Hours

0.00

Tool ID

300

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 10/12/13

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		WORK ORDER CI	HANGES				
STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR: WORK ORDER NON-CONFORMANCE (NCR)								
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Picklist Print

Thursday, October 28, 2010 10:20:39 AM

Work Order ID: 63375

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube





Start Date: 10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010

Page 1

Required Qty: 1.00

Comments:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C

07-02-23 Added SS Wearplates & Gaskets JLM

IPP Rev:D

replace NAS1515H3L to D3672-1 DD

IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

IPP Rev:F

08-06-02

07-12-06

add comment DD verified by:EC

IPP Rev:G 08-10-09 revise details DD verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D2600-1-190 Extrusion Round 3" 206	######################################	Manufactured	No			110	Each	63.0000	1	1 .		
				Location LG	47575 59874	<u>Loc</u>	Oty 63 15 48	Loc Code). <u>-</u>			0-11-3
D3285-1		Manufactured	No			110	Each	141.0000		1		
				<u>Location</u> LG	52511 52647	Loc	Qty 141 74 · 67	Loc Code	 		- - Bi	G-10-11-03
D3282-041 Float Web (206L/407)	I	Manufactured	No	.: •	BL 3389	150	Each	0.0000	. I	1		B 10/11/1

Dait Ac	Jospace	LIG								
W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print	414						Page 2
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Work Order ID: 63375							9
Parent Item: D206-642-541							
Parent Item Name: Replacement Skidte	ube			· · · · · · · · · · · · · · · · · · ·	Start Date: 1 Start Qty: 1	•	d Date: 11/11/2010 ed Qty: 1.00
D2649 Cross Bolt Spacer	Manufactured	No		190 Each	107.0000 12	12 BE/	0/11/26
			Location LG 58545 60652 61496 62889	Loc Oty 107 2 4 13 88	Loc Code	3. <i>633</i> 5 9 	` *12
D3275-1 Crossbolt Spacer	Manufactured	No	02807	190 Each	216.0000 12	12 B(5	- 10/11/25
			Location LG 53453 61646 62399	Loc Qty 216 8 102 106	Loc Code &	63546 	x/2
CR3212-4-03 Cherry Rivet	Purchased	No		250 Each	1,874.000 2	A 10/11/30)
			Location ST311 111359 112314 114436 114450 114859	Loc Oty 1874 5 2 448 71 1348	<u>Loc Code</u>		

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W/O:			V	ORK ORDER CHAI	NGES				1	.	
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NCR:	NCR:		WORK OR	DER NON-CONFOR	MANCE (NCR)	1				
DATE	STEP Description of NC			Section B		Verific	ation	Approval	Approval		
	OIL.	Section A	Initial Chief Eng	Action Description Chief Eng	on :	Sign & Date	Secti	on C	Chief Eng	QC Inspector	
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Picklist Print								Page 3
Thursday, October 28, 2010 10:20:39	AM							
Work Order ID: 63375								9
Parent Item: D206-642-541								
Parent Item Name: Replacement Skidte	ube	1 1881118 1818 11811 88	148 MILL 118019 OTHE TIBLE TIBLE			Start Date: 1	Required Date: 11/11/2010	
						Start Qty: 1	.00	Required Qty: 1.00
D3415-041	Manufactured	No		250	Each	52.0000 1	<u> </u>	11(130
		·	<u>ation</u>	Lo	oc Oty	Loc Code		
		ST0			52			
CCR264SS3-3	Purchased	No	33842	250	52 Each	416.0000 2	2	
Cherry Rivet	i di citasca						7.1.1	011130
•		Loc	<u>ation</u>	Lo	oc Qty	Loc Code		
		ST3			416			
			112314 113539		4 44			
			113973		368		-x2	
ALS4-1032-130	Purchased	No		250	Each	2,653.000 78	78	,
-							JU 10	3/11/30
		Loc	ation	Lo	oc Qty	Loc Code		
		PKO			886	22116049		
		ama	114723		886	XX 116 04 4	<u> </u>	
		ST2	82 110511		1 7 28 10			
			115911		1718			•
		ST3			39			
			114654		39			

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DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	egory:	NCR: Yes N	lo DQA:	Date: _	· · · · · · · · · · · · · · · · · · ·
	R	esolution:	Disposition	on:	QA: N/C Clo	sed:	Date: _	
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DATE	CTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
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Picklist:Print Thursday, October 28, 2010 10:20	·30 4M							Page 4	
Work Order ID: 63375								9	
Parent Item: D206-642-541 Parent Item Name: Replacement SI	xidtube		11 11 1 1 1 1 1 1 1 1				Start Date: 10/28/2010 Required Date: 11 Start Qty: 1.00 Required Qty: 1.		
D3536-15 Gasket	Manufactured	No		270	Each	18.0000 1	1	10/12/08	
			Location FP	<u>L</u>	6 1 5 12 1 11	Loc Code B63568	V\		
D3536-23	Manufactured	No	02437	270	Each	3.0000 1	<u> </u>	10/12/08	
·			Location FP011 61237	<u>L</u> (3 3	Loc Code B 63238	_X/		
D3536-35 Gasket	Manufactured	No		270	Each	16.0000 1	1 <u> </u>	10/12/08	
			Location FP012 58683 61692 62462	<u>L</u>	16 1 3 12	Loc Code B63579			
D3536-39	Manufactured	No	02102	270	Each	12.0000 1	1 9U	30/12/01	
			Location FP12 58215 58571	<u>L</u> (12 1 1 11	Loc Code B63578			
Thursday, October 28, 2010 10:20	:39 AM		Shop Pa	cket Print				Page 4	

Dail Ae	rospace	Liu							
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
D.47F		Description of NC		Corrective Action Section		Verifi	cation	Approval Chief Eng	Approval
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					<u>.</u>				
	i l		1					1	

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Thursday, October 28, 2010 10:20:39 AM

Work Order ID: 63375

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



61241 62241

62707

Start Date: 10/28/2010

Required Date: 11/11/2010

Page 5

Start Qty: 1.00

Required Qty: 1.00

D3535-15

Wearshoe	

Manufactured

Manufactured

Manufactured

No

No

No

270

270

Each

Loc Qty

Loc Qty

22

3

13

Each

Each

16

11

22.0000

Loc Code

26.0000

D3535-35	

Location FP018

Location

FP18

26 60865 6 62461 12 62969 270

Loc Code



Wearshoe

Wearshoe

Location Loc Qty FP18 27

60233 62945

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	Re	solution:	Disposition):	QA: N/C Cld	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section	ection B		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	By Date Qty Approval Chief Eng / Prod Mgr NCR: Yes No DQA: Date: QA: N/C Closed: Date: ANCE (NCR)	QC Inspector			
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Thursday, October 28, 2010 10:20):39 AM										Page 6
Work Order ID: 63375									.,		9
Parent Item: D206-642-541											ľ
Parent Item Name: Replacement S	kidtube	:	014 (181) BB(18 B			l li	S	tart Date:	10/28/2010	Required Date: 11/1	1/2010
								Start Qty:		Required Qty: 1.00	
D3535-23 Wearshoe	Manufactured	No			270	Each	28.0000		M 10	112/08	
			<u>Locatio</u>	<u>on</u>	<u>Lo</u>	c Oty	Loc Code				
			FP			7				-	
				61830		6				-	
			FP021	60231		21				-	
				62706		8 13			<u> </u>	-	
D3537-3	Manufactured	No			270	Each	40.0000	1	1	-	
Wearpad									M 10	112/08	
			Locatio	<u>on</u>	<u>Lo</u>	c Oty	Loc Code				
			FP17			40				_	
				60866		3			-	_	
				61674 62705		17 20				-	
D3537-1	Manufactured	No		02705	270	Each	66.0000	9	9	-	
	Manaractured				2,0		00.0000			112106	*
			Location	<u>on</u>	<u>Lo</u>	c Oty	Loc Code B 6 3	٠			
			FP			1	863	545	<u></u>	_	
				55465		1				_	
			FP017			59				_	
				61986		15				<u>.</u>	
			FP17	62209		44			_	-	
			FF1/	57713		6 3				_	
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Thursday, October 28, 2010 10:20:39	' AM						
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Parent Item Name: Replacement Skidt	ube		#### #### #### #######################	181	Start Date	10/28/2010	Required Date: 11/11/2010
					Start Qty	1.00	Required Qty: 1.00
AN960C10L NAS1149C0332 R	Purchased	No	270	Each	29.0000 80	80	
Washer						M	10/12/08
		Location	<u>Lo</u>	c Oty	Loc Code		
		ST245	7534	29 29	M115832	08v_	
AN960C416 NAS1149C0463 R	Purchased	No	270	Each	30.0000 1	1	_
washer						<u>Il</u>	10/12/08
		Location	<u>Lo</u>	c Oty	Loc Code		
		ST346	0993	30 30	XN 115358	<u> </u>	<u>. </u>
D3672-1	Manufactured	No	270	Each	847.0000 2	2	

Loc Qty

847

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Parent Item Name: Replacement S	kidtube		11011 30110 3011 110012		1100		art Date: I		Required Date: 11/11/2010 Required Qty: 1.00
AN3C4A	Purchased	No		270	Each	2,233.000	80	90 M	10/12/08
			Location	<u>I</u>	oc Oty	Loc Code			
			ST303		3			-	
				5438	3				
			ST350	4108	2230				
				1416	14 12				
				1523	2				
				5300	202				
				5589	1000				
ANAGEA			115	5936	1000				<u> </u>
AN4C5A BOLT	Purchased	No		270	Each	481.0000		1	rolizlog
			Location	<u>I</u>	oc Oty	Loc Code			
			ST346		481				
				0552	4				
D2646		,	112	2243	477			X(
Aft Cap	Manufactured	No		270	Each	45.0000		<u> </u>	10/12/08
			Location	<u>I</u>	oc Oty	Loc Code			
			FP-4		35				
			<u>573</u>	332	35			X	
			fp5		6				
			626	552	6				
			FP6		4				
			526	563	4				

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Picklist Print

Thursday, October 28, 2010 10:20:39 AM

Work Order ID: 63375

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube

Manufactured

No



Start Date: 10/28/2010

Required Date: 11/11/2010

Page 9

Start Qty: 1.00

Required Qty: 1.00

D3413-1

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ling	•	

Location	Loc Qty	Loc Code	
ST473	23	B62961	
51586	1		
53446	7		
61322	15		

Each

23.0000

270

W/O:		WORK ORDER CHANGES									
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			, ,								
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Resolution:			Disposit	on:	QA: N	/C Clo	sed:		Date: _		
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DATE	STEP	Description of NC			Section B		Verific	cation	Approval	Approval	
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	DESIG	CP	DRAWN BY	DART AEROSPACE USA, INC.,
	CHECK	(ED 🚜	APPROVED 4	DRAWING NO. REV. D
		#	#	D3274 SHEET 1 OF 4
ı	DATE			TITLE SCALE
	06.1	2.19		SKIDTUBE ASSEMBLY NTS
	Α		04.03.15	NEW ISSUE
	В		04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
	С		05.03.16	ADD -043; NEW INSERTS
	D		06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

HOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

Qty	Qty		
-041	-043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	Х	D3274-043	SKIDTUBE ASSEMBLY
		50000 1 010	EVENIOUS
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
			NICETT (AND 1 1000 100 AL OJ 1000 100 AEL O 1000 100)
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	11	AN4C5A	BOLT
11	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

- 1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2. DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

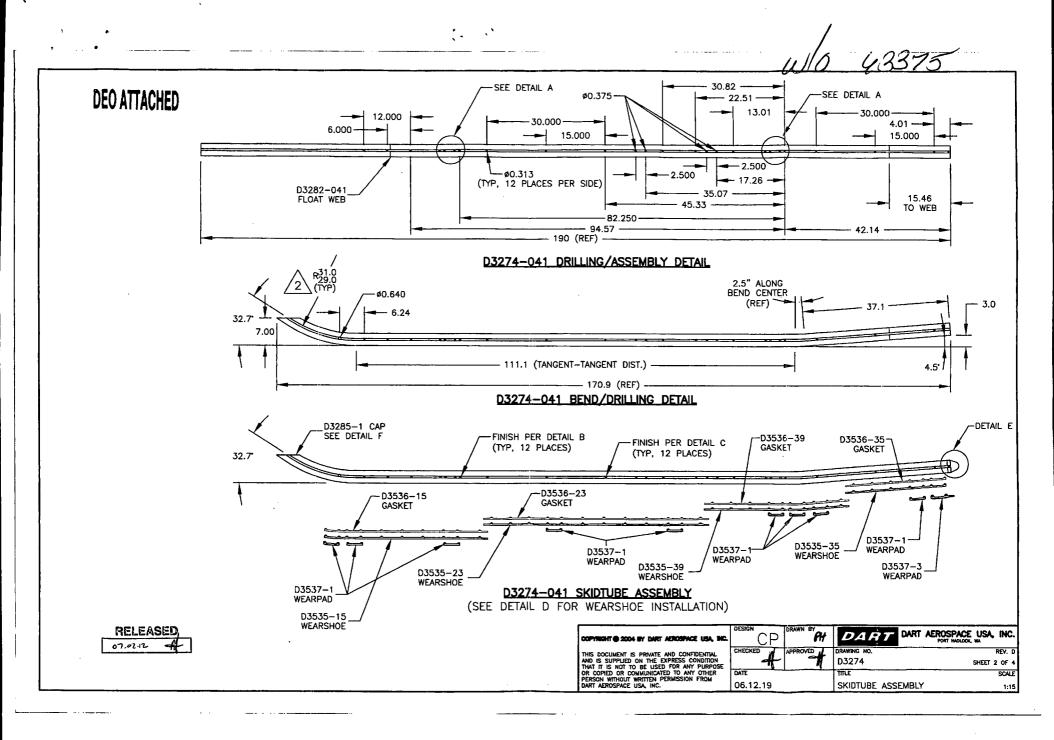
- 3. ALL HOLES DRILLED ON CENTERLINES.
- 4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 5. WELDING TO BE DONE PER DART QSI 004.
- 6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- 8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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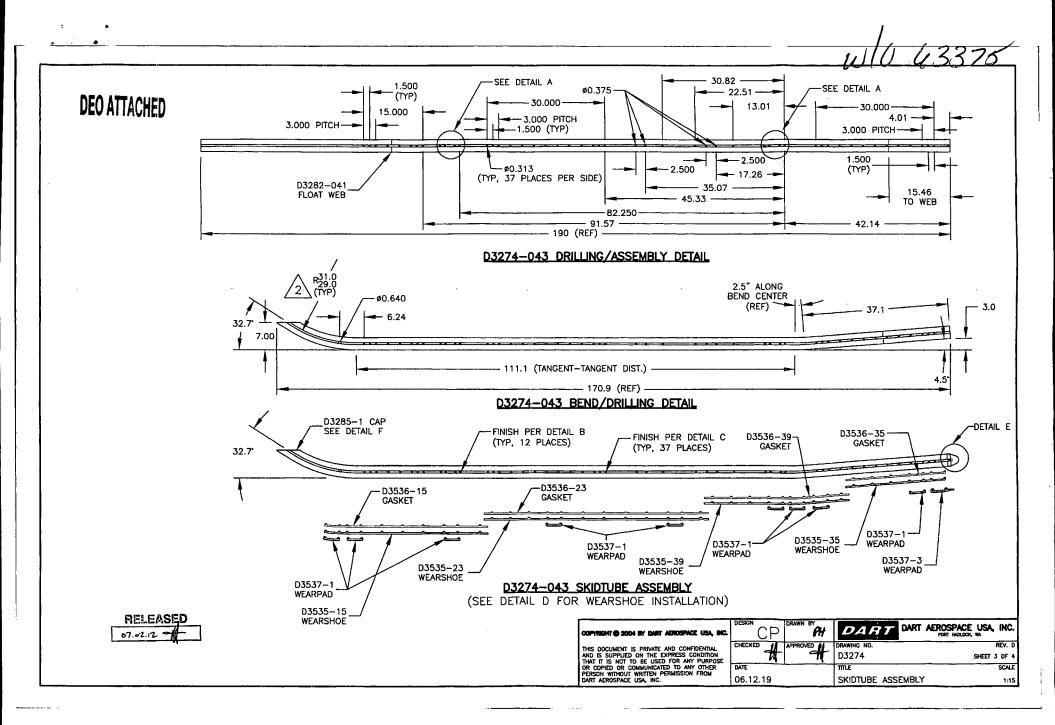
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W/O:			WORK ORDER (CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:PAR #:		PAR #:	PAR #: Fault Category:		NCR: Yes No DQA:			
		ution:	Disposition:	QA: N/C	QA: N/C Closed: Da			ıte:

NCR:	á	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	Approval Chief Eng				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector			
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W/O:			W	ORK ORDER CHANG	ES			•		
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Part No	·	PAR #:	Fault Cat	tegory:	_ NCR: `	es N	10 DQ	A :	_ Date: _	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date		ion C	Chief Eng	QC Inspector
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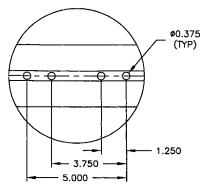


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STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	STEP					STEP PROCEDURE CHANGE By Date Qty Chief Eng /

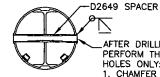
Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
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NCR:			WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval		
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		·								

DETAIL A: DRILL DETAIL



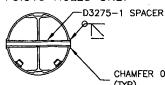
DETAIL BFOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.375 HOLES ONLY:

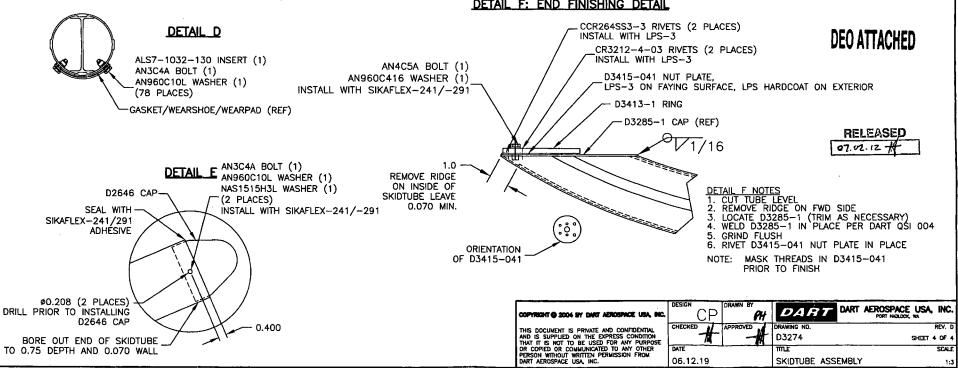
- 1. CHAMFER HOLE 0.030x45°
- 2. INSERT D2649 SPACER
- 3. WELD INTO PLACE AND GRIND FLUSH
- 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45* (TYP)

DETAIL F: END FINISHING DETAIL



W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
						!		; ;				
Part No:		PAR #:	Fault Cate	gory:	_ NCR: Yes N	lo DQA:	Date: _					
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PRAWING NO	၁.	TITLE	, REV. D	DART AEROSPACE US	A, INC D.E.O. NO.	SHEET NO.	SCALE
D3274		SKIDTUBE ASSEMBLY		ENGINEERING ORD	DER D3274-D-1	SHEET 1 OF 1	NTS
DRAWN	R	CHECKED		MFG. APPR.	APPROVED ,	DE APPR.	•
DATE	09.06.	.17 DATE 09	.06-23	DATE 59/06/23	DATE 09/06/23	DATE 09.06.23	

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

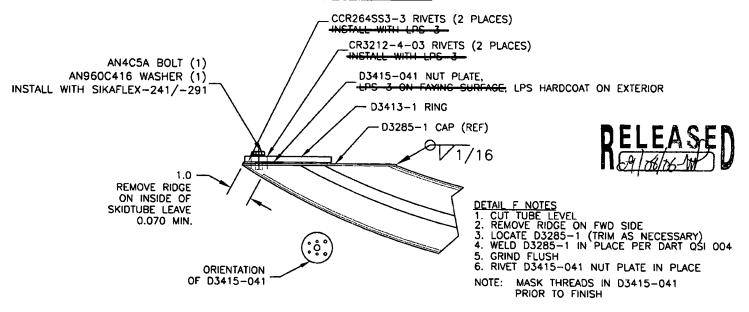
AMEND NOTE 8: "SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

w/043375

DETAIL F: END FINISHING DETAIL



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W/O:		WORK ORDER (WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									
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Part No) :	PAR #: Fault Category:	NCR: Yes	No DQ	- - A:	Date:			

Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

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DATE STEP		Description of NC		Corrective Action Section B				
		Section A	Initial Chief Eng			Verification Section C	Approval Chief Eng	Approval QC Inspector
		,						:
		_						
		•				•		
→ ⊀								

NO. 241

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclay Elliott	
Job number: 62380 で	
Part number: D306 (42 · 54)	
Description: 206 5k.a	
Welding Process: Tig Mig]	*.
Base materiel: Huminian	
Current: AC DC]	99.1

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[i] fail[] pass[] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[.] fail[] pass[.] fail[] pass[.] fail[] pass[.] fail[] pass[.] fail[] pass[.] fail[]
Qualifier DID	Date of Test Coupon 10.09.30
4	

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.